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1270 Aberdeen St
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D206-642-541
Job Sheet 200928



Part No: D206-642-541

Job Qty: 1 pcs

Part Name: Repl.Skid.,High Gear,Std Wearplates Fits LH/RH, DART Tri-Bag Float Comp.



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/19/19

Job Tracking No:

Due Date: 10/18/19

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG D3274-041 REV G IPP Rev:F 08-06-02 add comment DD verified by:EC IPP Rev:G 08-10-09 revise details DD verified by:EC IPP Rev:H 13.09.05 CHG004/ ECN13-634 DD VERF:JLM IPP REV:I 14.04.28 AS PER ECN14-520 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs	10/18/19		0.00	2.17	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
114	QC 5	1 pcs	10/18/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
116	QC 10	1 pcs	10/18/19		0.00	0.00	QC 10 - 10		
							QC 10 - 18		
							QC 10 - 24		
							QC 10 - 43		



Container No: S218247



Part: D206-642-541

Job No: 200928

Serial No/Batch: S218247

Revision: G

Inspector:

Exp Date:

Instructions: FAA STC SA00475SE 18/10/17, STC SH98-

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CANADA
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120 Handfinish - 1-1 Chemical-B4B	1 pcs	10/18/19	0.00 0.68	QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	★ OCT 11 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
130 QC 7	1 pcs	10/18/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	

					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	M/LG TF
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
					QC 7 - 76	
150 Skidtubes - 2 - B4B	1 pcs	10/18/19	0.00 2.08	30min TF 30min TF	Skidtubes - 1 - B4B	
					Skidtubes - 2 - B4B	
					Skidtubes - 3 - B4B	
					Skidtubes - 4 - B4B	TF
					Skidtubes - 5 - B4B	
					Skidtubes - 6 - B4B	
					Skidtubes - 7 - B4B	
160 QC 5	1 pcs	10/18/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	BE M/LG
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
170 Skidtubes - 3 - B4B	1 pcs	10/18/19	0.00 2.17		Skidtubes - 1 - B4B	
					Skidtubes - 2 - B4B	
					Skidtubes - 3 - B4B	M/LG M/LG
					Skidtubes - 4 - B4B	
					Skidtubes - 5 - B4B	
					Skidtubes - 6 - B4B	
					Skidtubes - 7 - B4B	
180 QC 5	1 pcs	10/18/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	BE
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	

				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
190 Skidtubes - 4 - B4B	1 pcs	10/18/19	0.00 2.75	Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	TF
				Skidtubes - 5 - B4B	BF
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
200 QC 5	1 pcs	10/18/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	DAS
				QC 5 - 68	NOV 04 2019 68
				QC 5 - 9	9-89
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
210 QC 10	1 pcs	10/18/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
220 Handfinish - 2-1 Pressure-B4B	1 pcs	10/18/19	0.00 0.45	Handfinish - 2 - 1 - B4B	
				Handfinish - 2 - 2 - B4B	NOV 04 2019
				Handfinish - 2 - 3 - B4B	
				Handfinish - 2 - 4 - B4B	
230 Spray Paint - 2 - B4B	1 pcs	10/18/19	0.00 0.40	Spray Paint - 1 - B4B	
				Spray Paint - 2 - B4B	Rd 19-11-5
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
240 QC 14	1 pcs	10/18/19	0.00 0.00	QC 14 - 15	M 19-11-15
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	

						QC 14 - 9	
						QC 14 - 68	
						QC 14 - 40	
						QC 14 - 19	
						QC 14 - 43	
						QC 14 - 24	
						QC 14 - 61	
						QC 14 - 81	
244 Handfinish - 3-1- WingWalk-B4B	1 pcs	10/18/19	0.00	0.50		Handfinish - 3 - 1 - B4B	ML 14-11-06
						Handfinish - 3 - 2 - B4B	
						Handfinish - 3 - 3 - B4B	
						Handfinish - 3 - 4 - B4B	
						Handfinish - 3 - 5 - B4B	
246 QC 3	1 pcs	10/18/19	0.00	0.00		QC 3 - 10	BEB 19-11-06
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
250 Handfinish - 4-1-Assembly-B4B	1 pcs	10/18/19	0.00	0.45		Handfinish - 4 - 1 - B4B	ML 14-11-06
						Handfinish - 4 - 10 - B4B	
						Handfinish - 4 - 11 - B4B	
						Handfinish - 4 - 12 - B4B	
						Handfinish - 4 - 13 - B4B	
						Handfinish - 4 - 14 - B4B	
						Handfinish - 4 - 15 - B4B	
						Handfinish - 4 - 2 - B4B	
						Handfinish - 4 - 3 - B4B	
						Handfinish - 4 - 4 - B4B	
						Handfinish - 4 - 5 -	

260 QC 5	1 pcs	10/18/19	0.00 0.00	B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	DAS
				QC 5 - 51	81
				QC 5 - 58	9-89
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
270 Handfinish - 4-2-Assembly-B4B	1 pcs	10/18/19	0.00 0.68	QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				Handfinish - 4 - 1 - B4B	
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
280 QC 5	1 pcs	10/18/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	

NOV 06 2019

all 19-11-06

					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	DAS
					QC 5 - 68	NOV 06 2019 68
					QC 5 - 9	9-89
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
290	Packaging 3-1 - Stock - B4B	1	10/18/19	0.00 0.00	Packaging 3 - 1 - B4B	
	pcs				Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
295	DC - 1 - B4B	1	10/18/19	0.00 0.00	DC - 1 - B4B	
	pcs				DC - 2 - B4B	
300	QC 21 - FG	1	10/18/19	0.00 0.00	QC 21 - FG - 21	
	pcs				QC 21 - FG - 70	
					QC 21 - FG - 53	

Part Op 110 - (Skidtubes) ****VERIFY AND INSPECT THE MATERIAL PRIOR TO USE**** 1- remove fwd indexing ridge as per Descriptions: dwg D3274. Prepare for welding 2- weld fwd cap as per dwg D3274 and QSI004 AR Aluminum Rod Batch: 139011/138989 3- grind fwd cap weld on top surface only 4- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end. 5-Drill Aft cap pilot hole using DT8025 6 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D and DT8742. Drill 3/16" pilot holes as per Dwg D3274 7 -Remove inner indexing ridge on aft end of

skidtube as per Dwg D3274 scribe batch # 8 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

114 - (QC5- Inspect part completeness to step on W/O)

116 - (QC10- Inspect visual per QSI004- ground welds)

120 - (Chemical Conversion Coat per QSI005 4.1)

130 - (QC7-Inspect Chemical Conversion Coat)

150 - (Skidtubes) 1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274 2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube 3-Bond web in place as per Dwg D3274 & QSI 015. (Adhere for 12 hours)

160 - (QC5- Inspect part completeness to step on W/O)

170 - (Skidtubes) 1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position. 2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2 OPEN HOLES TO .297" . Deburr 3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD END OF TUBE DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES) REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES 4- Countersink crossbolt spacer holes as per Dwg D3274 5- prepare for welding

180 - (QC5- Inspect part completeness to step on W/O)

190 - (Skidtubes) 1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod 3-Grind cross bolt welds flush as per Dwg D3274.

****INSPECT FOR PIN HOLES IN WELD**** 4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.

200 - (QC5- Inspect part completeness to step on W/O)

210 - (QC10- Inspect visual per QSI004- ground welds)

220 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch

230 - (Spray Paint / NDT Room) Make sure Nut Plate Thread is protected using paint screw., 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: 5200299 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 5213125

240 - (QC14- Inspect Spray Paint)

244 - (Wing Walk as per dwg QSI005 4.4 Batch 5305862

246 - (QC3- Inspect Part Finish)

250 - (Assemble as per dwg) 1-Install Nut Plate as per Dwg D3274. Apply LPS-PROCYON to Nut Plate and rivets.

260 - (QC5- Inspect part completeness to step on W/O) Inspect Nut Plate & Inserts

270 - (Assemble as per dwg) 1-Install wearpads as per Dwg D3274. 2-Install ring as per Dwg D3274 3-Inspect for foreign objects as per QSI 024 4-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

280 - (QC5- Inspect part completeness to step on W/O)

290 - (Identify as per dwg & Stock Location: _____) Location : FG073

295 - (Document Control) Photocopy bluefile & type labels per PPP D206-642- 541 CHG005

300 - (QC21- Final Inspection - Work Order Release) 4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 using DT10280 and deburr.

Job BOM

Part / Item	Component Name	Quantity	Operation
D3274-041BENT	Skidtube Assembly 206	1 pcs (1 ea)	110-Skidtubes - 1
D3285-1	Cap	1 pcs (1 ea)	110-Skidtubes - 1
D3282-041	Float Web (206L/407)	1 pcs (1 ea)	150-Skidtubes - 2 - B4B
D2649	Cross Bolt Spacer	12 pcs (12 ea)	190-Skidtubes - 4 - B4B
D3275-1	Cross Bolt Spacer	12 pcs (12 ea)	190-Skidtubes - 4 - B4B
ALS4-1032-130	Rivnut	78 Ea (78 ea)	250-Handfinish - 4-1-Assembly-B4B
CCR264SS3-3	Cherry Rivet	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B
CR3212-4-03	Cherry Rivet	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B
D3415-041	Nut Plate	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B
AN3C4A	Bolt	80 Ea (80 ea)	270-Handfinish - 4-2-Assembly-B4B
AN4C5A	Bolt	1 Ea (1 ea)	270-Handfinish - 4-2-Assembly-B4B
D2646	Aft Cap	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B
D3413-1	O-Ring	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B
D3537-1	Wearpad	9 pcs (9 ea)	270-Handfinish - 4-2-Assembly-B4B
D3537-3	Wearpad	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B
D3672-1	Washer, Phenolic	2 pcs (2 ea)	270-Handfinish - 4-2-Assembly-B4B
D4956-15	Wearplate Fwd	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B
D4956-23	Wearplate Center Fwd	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B
D4956-35	Wearplate Aft	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B
D4956-39	Wearplate Center Aft	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B
NAS1149C0332R	Washer (AN960C10L)	80 Ea (80 ea)	270-Handfinish - 4-2-Assembly-B4B
NAS1149C0463R	Washer (AN960C416)	1 Ea (1 ea)	270-Handfinish - 4-2-Assembly-B4B

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Container

5216847
5043738
5219825
5225932 x 8
5199330
5057257
5094572
5163230-3
5218586
5228822
5057196
5197616
F165082
5225791
5218782
5200829
5218726
5804837
5201005
F164008
5218151
5104572

012742

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D3274-041BENT	1	5	0
	D3285-1	1	7	0
150-Skidtubes - 2 - B4B	D3282-041	1	3	0
190-Skidtubes - 4 - B4B	D2649	12	83	0
	D3275-1	12	196	0
250-Handfinish - 4-1-Assembly-B4B	ALS4-1032-130	78	5,946	0
	CCR264SS3-3	2	55	0
	CR3212-4-03	2	38	0
	D3415-041	1	1	0
	AN3C4A	80	584	0
270-Handfinish - 4-2-Assembly-B4B	AN4C5A	1	70	0
	D2646	1	58	0
	D3413-1	1	19	0
	D3537-1	9	144	0
	D3537-3	1	10	0
	D3672-1	2	1,439	0
	D4956-15	1	7	0
	D4956-23	1	16	0
	D4956-35	1	21	0
	D4956-39	1	9	0
	NAS1149C0332R	80	2,920	0
	NAS1149C0463R	1	205	0
Part Specifications				
Specifications could not be found.				

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QTY	QTY	Part Number	Description
1	1	D274-441	SKIDTUBE ASSEMBLY
1	1	D274-442	SKIDTUBE ASSEMBLY
1	1	D274-443	SKIDTUBE ASSEMBLY
1	1	D274-444	SKIDTUBE ASSEMBLY (FOR PH)
1	1	D2800-1-240	EXTRUSION
1	1	D2846	AFT CAP
12	12	D2848	CROSS BOLT SPACER
12	12	D276-1	CROSS BOLT SPACER
1	1	D276-2	FLAT WEB
1	1	D276-3	CAP
1	1	D276-4	RING
1	1	D276-5	NUT PLATE
1	1	D276-6	WEARPAID
1	1	D276-7	WEARPAID
1	1	D276-8	WEARPAID
1	1	D276-9	WEARPAID
1	1	D276-10	WEARPAID
1	1	D276-11	WEARPAID
1	1	D276-12	WEARPAID
1	1	D276-13	WEARPAID
1	1	D276-14	WEARPAID
1	1	D276-15	WEARPAID
1	1	D276-16	WEARPAID
1	1	D276-17	WEARPAID
1	1	D276-18	WEARPAID
1	1	D276-19	WEARPAID
1	1	D276-20	WEARPAID
1	1	D276-21	WEARPAID
1	1	D276-22	WEARPAID
1	1	D276-23	WEARPAID
1	1	D276-24	WEARPAID
1	1	D276-25	WEARPAID
1	1	D276-26	WEARPAID
1	1	D276-27	WEARPAID
1	1	D276-28	WEARPAID
1	1	D276-29	WEARPAID
1	1	D276-30	WEARPAID
1	1	D276-31	WEARPAID
1	1	D276-32	WEARPAID
1	1	D276-33	WEARPAID
1	1	D276-34	WEARPAID
1	1	D276-35	WEARPAID
1	1	D276-36	WEARPAID
1	1	D276-37	WEARPAID
1	1	D276-38	WEARPAID
1	1	D276-39	WEARPAID
1	1	D276-40	WEARPAID
1	1	D276-41	WEARPAID
1	1	D276-42	WEARPAID
1	1	D276-43	WEARPAID
1	1	D276-44	WEARPAID
1	1	D276-45	WEARPAID
1	1	D276-46	WEARPAID
1	1	D276-47	WEARPAID
1	1	D276-48	WEARPAID
1	1	D276-49	WEARPAID
1	1	D276-50	WEARPAID
1	1	D276-51	WEARPAID
1	1	D276-52	WEARPAID
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1	1	D276-94	WEARPAID
1	1	D276-95	WEARPAID
1	1	D276-96	WEARPAID
1	1	D276-97	WEARPAID
1	1	D276-98	WEARPAID
1	1	D276-99	WEARPAID
1	1	D276-100	WEARPAID

GENERAL NOTES:

1. MATERIAL: N/A
2. FINISH: N/A
3. ON-445: CHEMICAL CONVERSION COAT PER DART Q81 005 4.1 PRIOR TO INSTALLING D3282-041 WEB PRIME (REF. 4.2.1.3.3) OUTSIDE ONLY AND PAINT WHITE PER DART Q81 005 4.2 BLACK ANTI-SKID PAINT A8 INDICATED TO 0.5" ABOVE LOCATION RIDGE PER DART Q81 005 4.4
4. ON-446: CHEMICAL CONVERSION COAT PER DART Q81 005 4.1 PRIOR TO INSTALLING D3282-041 WEB PRIME (REF. 4.2.1.3.3) INSIDE AND OUTSIDE PER Q81 005 4.2.1 PAINT BLACK PER Q81 005 4.2.2 USING CABOT 37059 CAMOFLAG BLACK PER MIL-PRF, BLACK TYPE (CLASS H)
5. ON-447: CHEMICAL CONVERSION COAT PER DART Q81 005 4.1 PRIOR TO INSTALLING D3282-041 WEB PRIME (REF. 4.2.1.3.3) INSIDE AND OUTSIDE PER Q81 005 4.2.1 PAINT BLACK PER Q81 005 4.2.2 USING CABOT 37059 CAMOFLAG BLACK PER MIL-PRF, BLACK TYPE (CLASS H)
6. ON-448: CHEMICAL CONVERSION COAT PER DART Q81 005 4.1 PRIOR TO INSTALLING D3282-041 WEB PRIME (REF. 4.2.1.3.3) INSIDE AND OUTSIDE PER Q81 005 4.2.1 PAINT BLACK PER Q81 005 4.2.2 USING CABOT 37059 CAMOFLAG BLACK PER MIL-PRF, BLACK TYPE (CLASS H)
7. ON-449: CHEMICAL CONVERSION COAT PER DART Q81 005 4.1 PRIOR TO INSTALLING D3282-041 WEB PRIME (REF. 4.2.1.3.3) INSIDE AND OUTSIDE PER Q81 005 4.2.1 PAINT BLACK PER Q81 005 4.2.2 USING CABOT 37059 CAMOFLAG BLACK PER MIL-PRF, BLACK TYPE (CLASS H)
8. ON-450: CHEMICAL CONVERSION COAT PER DART Q81 005 4.1 PRIOR TO INSTALLING D3282-041 WEB PRIME (REF. 4.2.1.3.3) INSIDE AND OUTSIDE PER Q81 005 4.2.1 PAINT BLACK PER Q81 005 4.2.2 USING CABOT 37059 CAMOFLAG BLACK PER MIL-PRF, BLACK TYPE (CLASS H)
9. ON-451: CHEMICAL CONVERSION COAT PER DART Q81 005 4.1 PRIOR TO INSTALLING D3282-041 WEB PRIME (REF. 4.2.1.3.3) INSIDE AND OUTSIDE PER Q81 005 4.2.1 PAINT BLACK PER Q81 005 4.2.2 USING CABOT 37059 CAMOFLAG BLACK PER MIL-PRF, BLACK TYPE (CLASS H)
10. ON-452: CHEMICAL CONVERSION COAT PER DART Q81 005 4.1 PRIOR TO INSTALLING D3282-041 WEB PRIME (REF. 4.2.1.3.3) INSIDE AND OUTSIDE PER Q81 005 4.2.1 PAINT BLACK PER Q81 005 4.2.2 USING CABOT 37059 CAMOFLAG BLACK PER MIL-PRF, BLACK TYPE (CLASS H)
11. ON-453: CHEMICAL CONVERSION COAT PER DART Q81 005 4.1 PRIOR TO INSTALLING D3282-041 WEB PRIME (REF. 4.2.1.3.3) INSIDE AND OUTSIDE PER Q81 005 4.2.1 PAINT BLACK PER Q81 005 4.2.2 USING CABOT 37059 CAMOFLAG BLACK PER MIL-PRF, BLACK TYPE (CLASS H)
12. ON-454: CHEMICAL CONVERSION COAT PER DART Q81 005 4.1 PRIOR TO INSTALLING D3282-041 WEB PRIME (REF. 4.2.1.3.3) INSIDE AND OUTSIDE PER Q81 005 4.2.1 PAINT BLACK PER Q81 005 4.2.2 USING CABOT 37059 CAMOFLAG BLACK PER MIL-PRF, BLACK TYPE (CLASS H)
13. ON-455: CHEMICAL CONVERSION COAT PER DART Q81 005 4.1 PRIOR TO INSTALLING D3282-041 WEB PRIME (REF. 4.2.1.3.3) INSIDE AND OUTSIDE PER Q81 005 4.2.1 PAINT BLACK PER Q81 005 4.2.2 USING CABOT 37059 CAMOFLAG BLACK PER MIL-PRF, BLACK TYPE (CLASS H)
14. ON-456: CHEMICAL CONVERSION COAT PER DART Q81 005 4.1 PRIOR TO INSTALLING D3282-041 WEB PRIME (REF. 4.2.1.3.3) INSIDE AND OUTSIDE PER Q81 005 4.2.1 PAINT BLACK PER Q81 005 4.2.2 USING CABOT 37059 CAMOFLAG BLACK PER MIL-PRF, BLACK TYPE (CLASS H)

RELEASED
R 2016-07-26
ECP 15-114

REV.	DESCRIPTION	BY	DATE
G	ADD -045 CONFIGURATION (FOR PH) 2N AS-4, AS-8 REVISE NOTE 2, 7 & 12, ADD NOTE 14 (2N AS-1)	DS	18.04.25
F	REVISE NOTE 2: ADD ANTI-SKID PAINT, REMOVE GASKETS PER IN-D208-942 REV Q	DB	14.04.15
E	REVISE NOTE 2: FINISH NOW PRIME/PAINT WAS POWDERCOAT, REF. PAR13-258	DW	13.05.17
D	NEW INSERTS, SS WEARSHOE + GASKET	CP	08.12.19
C	ADD -045: NEW INSERTS	CP	05.03.18
B	MOVE SADDLE HOLE: 42.14 WAS 42.78	CP	04.08.09
A	NEW ISSUE	CP	04.03.15
DESIGN	CP	BY	DATE
DRAWN	RF		
CHECKED	AK		
MFG. APPR.	JLM		
APPROVED	DS		
DE APPR.			
DATE	16.04.25		

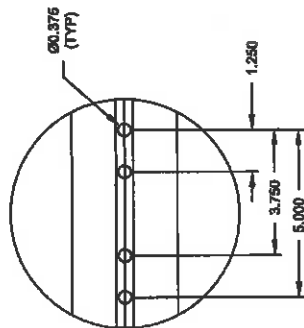
REV.	DESCRIPTION	BY	DATE
G	ADD -045 CONFIGURATION (FOR PH) 2N AS-4, AS-8 REVISE NOTE 2, 7 & 12, ADD NOTE 14 (2N AS-1)	DS	18.04.25
F	REVISE NOTE 2: ADD ANTI-SKID PAINT, REMOVE GASKETS PER IN-D208-942 REV Q	DB	14.04.15
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DESIGN	CP	BY	DATE
DRAWN	RF		
CHECKED	AK		
MFG. APPR.	JLM		
APPROVED	DS		
DE APPR.			
DATE	16.04.25		

SHC
R
ENH
UNCON
WTT
V (14)

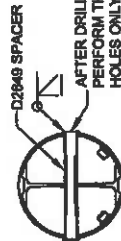
200928 HUS
6409-19

REV.	DESCRIPTION	BY	DATE
G	ADD -045 CONFIGURATION (FOR PH) 2N AS-4, AS-8 REVISE NOTE 2, 7 & 12, ADD NOTE 14 (2N AS-1)	DS	18.04.25
F	REVISE NOTE 2: ADD ANTI-SKID PAINT, REMOVE GASKETS PER IN-D208-942 REV Q	DB	14.04.15
E	REVISE NOTE 2: FINISH NOW PRIME/PAINT WAS POWDERCOAT, REF. PAR13-258	DW	13.05.17
D	NEW INSERTS, SS WEARSHOE + GASKET	CP	08.12.19
C	ADD -045: NEW INSERTS	CP	05.03.18
B	MOVE SADDLE HOLE: 42.14 WAS 42.78	CP	04.08.09
A	NEW ISSUE	CP	04.03.15
DESIGN	CP	BY	DATE
DRAWN	RF		
CHECKED	AK		
MFG. APPR.	JLM		
APPROVED	DS		
DE APPR.			
DATE	16.04.25		

RELEASED
2016-07-26



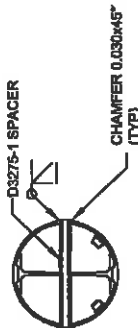
FOR Ø0.375 HOLES ONLY



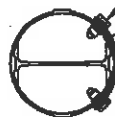
**AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375
HOLES ONLY:**

1. CHAMFER HOLE 0.030x45°
2. INSERT D2048 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. CBORE TO Ø0.313x0.75 DEEP

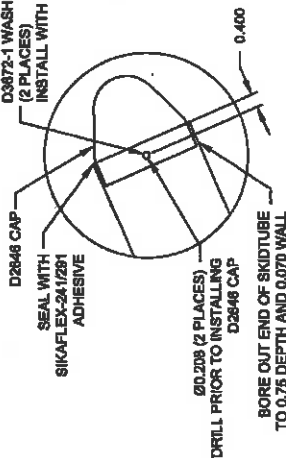
FOR Ø0.313 HOLES ONLY



AL57-1032-130 INSERT (1)
AN3C4A BOLT (1)
NAS1149C0332R WASHER (1)
778 PLACES)

WEARSHOE/WEARPAD (REF)

D2848 CAP —
D3872-1 WASHER (1)
NAST149C0332R WASHER (2 PLACES)



BORE OUT END OF SKIDTUBE
TO 0.75 DEPTH AND 0.070 WALL

RELEASED
2016-07-26

2016-07-21

DESIGN	GP	DART AEROSPACE USA, INC	
DRAWN	RF	EUGENE, OR	
CHECKED	AK	DRAWING NO.	REV. G
INFO. APPR.	JLM	D3274	SHEET 5 OF 5
APPROVED	DS	TITLE	SCALE
DATE	16.04.25	SKIDTUBE ASSEMBLY	
		COPYRIGHT © 1984 BY DART AEROSPACE USA, INC	
		THIS DOCUMENT CONTAINS INFORMATION OF COMMERCE. IT IS THE PROPERTY OF DART AEROSPACE USA, INC. IT IS TO BE KEPT SECRET AND NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE USA, INC.	

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 creating images or video.

DATE 16.04.25



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Large Fab ☐

Cross tube ☐
Small Fab ☐
Finishing ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐

Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Date: _____ Sequence #: _____

QTY Affected: _____

MRB (QSI042)

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong
☐	☐	☐	☐
Bending	Misaligned/off center	Folio/Program	Outside Tolerance
☐	☐	☐	☐
Crushing	BOM/Route	Grain Direction	Drawing
☐	☐	☐	☐
Cracks	Broken/Damage/Defect	Weld	Finish
☐	☐	☐	☐
Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing
☐	☐	☐	☐
Marks/Chatter	Drill Holes	Out of Sequence	Misread
☐	☐	☐	☐
Mislabeled	Fit/Function	Off-set/Set-up	
☐	☐	☐	

Other/Details: _____